

CLAIMS

1. A method for brazing aluminum alloy-assembled articles within a short period of time, which comprises
5 brazing aluminum alloy-assembled articles with a filler alloy having a liquidus temperature of 540°C or lower and a difference of temperature between the liquidus and the solidus temperature being 100°C or lower, wherein the
10 highest temperature reached in the assembled articles at the time of heating for brazing is set 40°C or more higher than the liquidus temperature but 585°C or lower.

2. The method for brazing aluminum alloy-assembled articles within a short period of time according
15 to claim 1, wherein elevation of the temperature after exceeding the liquidus temperature is continued without keeping the article at a fixed temperature.

3. The method for brazing aluminum alloy-
20 assembled articles within a short period of time according to claim 1 or 2, wherein a vacuum brazing method or a NB method is carried out in nitrogen gas atmosphere with flux of Cs series as non-corrosive flux.

25 4. The method for brazing aluminum alloy-

assembled articles within a short period of time according to any one of claims 1 to 3, wherein an alloy selected from the group consisting of (a) a Zn alloy containing 4.0 wt% of Al, (b) a Zn alloy containing 11.0 wt% of Al and 3.0 wt% of Cu, and (c) an Al alloy containing 6.0 wt% of Si, 25.0 wt% of Cu, and 5.0 wt% of Zn is used as the filler alloy.

5. An aluminum alloy-filler alloy usable at low temperature for brazing, which comprises Si in an amount of 4.0 wt% or more but less than 8.0 wt%, Zn in an amount of 7.0 wt% or more but 20.0 wt% or less and Cu in an amount of 10.0 wt% or more but 35.0 wt% or less, with the balance being made of aluminum and any unavoidable impurities.

6. An aluminum alloy-filler alloy usable at low temperature for brazing, which comprises Si in an amount of 5.0 wt% or more but less than 7.0 wt%, Zn in an amount of 9.0 wt% or more but 20.0 wt% or less and Cu in an amount of 19.0 wt% or more but 27.0 wt.% or less, with the balance being made of aluminum and any unavoidable impurities.